

Date: Tuesday, 7/18/2006 2:49:57 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT MAINTENACE STEP
Job Number	: 27953		
Estimate Number	: 12455		
P.O. Number	: N/A	Part Number	: D350591133
This Issue	: 7/18/2006 S.O. No. : N/A	Drawing Number	: D2946 REV <i>AB</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: <i>AB</i>
Previous Run	: 27605	Material	: N/A
Written By	: <i>[Signature]</i>	Due Date	: 8/20/2006 Qty: 10 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev:B 05.10.14 Modified step 10 KJ/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



(10)

Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-133 CHG002

06.07.28 KJ

2.0	D2622120C	Extrusion
-----	-----------	-----------



Comment: Qty.: 0.5000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
.500 D2622-120C	Extrusion	<i>B27077</i>

PE. 06.08.4

10

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.

3-Deburr

Ensure that 57.09" minimum extrusion is kept and identify to be used for D350-591-215/-216.

PE. 06.08.4

10

PE. 06.08.5

10

PE. 06.08.5

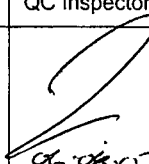
10

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

J. 06.08.07 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-08-07	3-2	No holes req'd in step, remove. Perm. Change					 06-08-07

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 7/18/2006 2:49:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT MAINTENACE STEP

Job Number: 27953

Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2734

End Plate ~~327281~~

PE-06-08-9

10

6.0

D2944

Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2944

Support

324351 = 2
327971 = 18

PE-06-08-9

10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Deburr and Bevel ends for welding

2-Weld (1) End Cap and (2) Lugs using Jig DT8440 as per Dwg D2946

A/R Aluminum Rod *m100660*

3-Grind End Cap welds flush

PE-06-08-9

10

PE-06-08-14

10

PE-06-08-14

10

8.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 9

200814 (10)

1206/08/15 (10)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAH 06:08:18 10

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PE-06-08-22

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 7/18/2006 2:49:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT MAINTENACE STEP

Job Number: 27953

Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush.

A/R AL ROD BATCH: *M150660 M15689*

P.E. 06-08-23 10

12.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

10/06/08/29 (10)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

a.m 06-08-30

(10)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-08-30

(10)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2946 and QSI 005 4.4

a.m 06-08-30

(10)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

10/04/09/6 (10)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

D22301

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Mounting Lug

Batch: *B25553 x 19462801 x 21 PB 06/08/31*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 7/18/2006 2:49:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT MAINTENACE STEP

Job Number: 27953

Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Mounting Lug

Batch: B27860 36x 4x B27579

20.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2606 f(s)/Unit Total: 12.6063 f(s)

Abrasion Strip 7.20" long x2

Batch: B27545

21.0

D2945

Step Mounting Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Step Mounting Plate

Batch: B24352 ✓

22.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bolt

Batch: M19278x3, M100327x17 ✓

23.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bolt

Batch: M100743 ✓

24.0

AN414A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Bolt

Batch: M100188 ✓

25.0

AN960JD416

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total: 140.0000 Each(s)

Washer

Batch: M19185 ✓

LB 06/08/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/09/07

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 7/18/2006 2:49:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT MAINTENACE STEP

Job Number: 27953

Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

MS21042L4

Nut



Comment: Qty.: 14.0000 Each(s)/Unit Total : 140.0000 Each(s)

Nut

Batch: M19085 ✓

RB 06/08/31

27.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

PC 6/9/6 (10)

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-213

Location: D

PPP Rev: D

PC 6/9/6 (10)

29.0

DC

DOCUMENT CONTROL



(10)

Comment: DOCUMENT CONTROL

Inspection Level 21

DB 06/09/07

Job Completion



U 060906

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

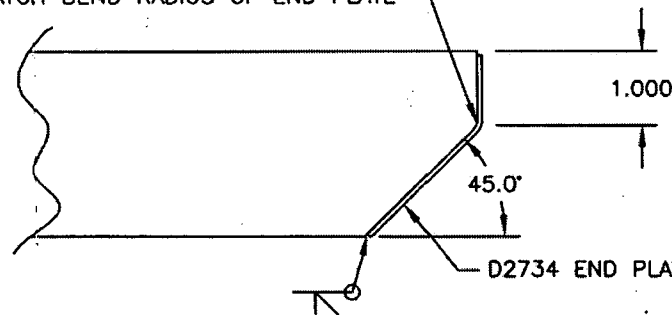
D2946 STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2946	Step Assembly	X
D2622-63	STEP EXTRUSION*	1
D2734	END PLATE	2
D2944	STEP MOUNTING PLATE	2

*cut per drawing

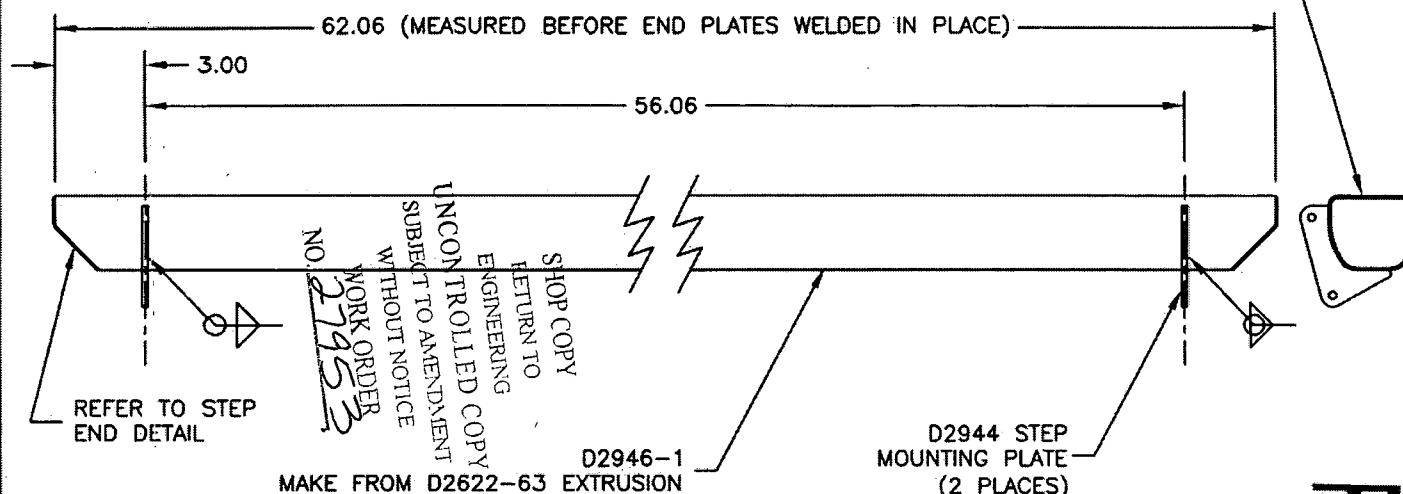
NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



D2946-041 STEP ASSEMBLY

D2946 STEP ASSEMBLY

- 1) MAKE FROM D2622 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	CP	DRAWN BY	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2946
DATE	05.11.14	TITLE	STEP ASSEMBLY	REV. B
A	99.12.13	NEW ISSUE		SHEET 1 OF 1
B	05.11.14	UPDATE FINISHING NOTE		SCALE 1:6

RELEASED
05.11.28